

Work Order ID 81940

81940

Page 1

March-21-12 9:52:05 AM

Item ID: D4545-048 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Retainer, Inner, RH (Top)
 Start Date: 21/03/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 04/04/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/21 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4545	B

100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									

Ep 12/03/22 (2)

110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab									

1- ASSEMBLE AND BEND TABS AS PER DWG
 2- TRANSFER DRILL HOLES AS PER DWG.
 3- DISASSEMBLE AND DEBURR
 4- DIMPLE HOLES AS PER DWG

SP 12/03/21 (2)

Ep 12/03/22 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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March-21-12 9:52:05 AM

Item ID: D4545-048 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Retainer, Inner, RH (Top)
Start Date: 21/03/2012 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 04/04/2012 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC7-Inspect Chemical Conversion Coat	0.00							
140									
QC	Memo	0.00							
Quality Control									

PTO

Dart Aerospace Ltd

W/O: 81940		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
1203-22	1203-22 145 146	Install nutplates before paint Permanent Change	<i>[Signature]</i>	1203-22	2	<i>[Signature]</i> C. [unclear]	<i>[Signature]</i> 1203-22

Part No: D 4545-048 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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March-21-12 9:52:05 AM

Item ID: D4545-048
Revision ID:
Item Name: Retainer, Inner, RH (Top)

Accept

N9000040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 21/03/2012 Start Qty: 2.00 ***2***
Required Date: 04/04/2012 Req'd Qty: 2.00 ***2***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 0.00

150

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10h35
320°F
11h05

0.00

2 2 29 12/03/23.

160 QC3- Inspect Part Finish 0.00

160

QC

Quality Control

Memo

0.00

2 12/03/23.

170 0.00

170

Small Fab

Small Fab

Memo

INSTALL NUT PLATES AS PER DWG

0.00

2 12/03/22 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00						12/03/22	SRR
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: 442 Memo	0.00 0.00						12/3/23	sf (20)
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						MLJ 12/03/26	MF 12-03-24

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NOTE: Date & initial all entries

Picklist Print

March-21-12 9:52:09 AM

Page 1

Work Order ID: 81940

81940

Parent Item: D4545-048

D4545-048

Parent Item Name: Retainer, Inner, RH (Top)

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.01.13 new issue DD verf:JLM
12.02.27 AS PER DWG REV.B DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4541-7 *D4541-7* Bracket		Manufactured	No			100	Each	3.0000	1	2		Ep 12/03/22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		3		B81264					
					78768	3							
D4542-7 *D4542-7* Retainer, Inner		Manufactured	No			100	Each	3.0000	1	2		Ep 12/03/22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		3		B80269					
					78774	3							
MS20426AD3-4 *MS20426AD3-4* RIVET		Purchased	No			170	Each	3,914.000	16	32		Ep 12/03/22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST316		3914							
					104374	1006							
					110398	2908							
MS21059L3K *MS21059L3K* Nutplate		Purchased	No			170	Each	0.0000	8	16		Ep 12/03/22	

M121114
(162)

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ITEM	QTY -041	QTY -042	QTY -043	QTY -044	QTY -045	QTY -046	QTY -047	QTY -048	PART NUMBER	DESCRIPTION
	X								D4545-041	RETAINER, LH INNER (LOWER)
		X							D4545-042	RETAINER, RH INNER (LOWER)
			X						D4545-043	RETAINER, LH INNER (SIDE)
				X					D4545-044	RETAINER, RH INNER (SIDE)
					X				D4545-045	RETAINER, LH INNER (TOP CORNER)
						X			D4545-046	RETAINER, RH INNER (TOP CORNER)
							X		D4545-047	RETAINER, LH INNER (TOP)
								X	D4545-048	RETAINER, RH INNER (TOP)
1	1								D4541-1	BRACKET
2		1							D4541-2	BRACKET
3			1	1					D4541-3	BRACKET
4					1	1			D4541-5	BRACKET
5							1	1	D4541-7	BRACKET
6	1								D4542-1	RETAINER
7		1							D4542-2	RETAINER
8			1	1					D4542-3	RETAINER
9					1	1			D4542-5	RETAINER
10							1	1	D4542-7	RETAINER
11	40	38	28	28	12	12	16	16	MS20426AD3-4	RIVET
12	19	18	14	14	6	6	8	8	MS21059L3K	NUTPLATE
13	1	1							MS21061L3K	NUTPLATE

~~8055~~ M.C.J
81940 12/03/21

RELEASED
2012-02-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIOR TO ASSEMBLY, POWDER COAT D4541-X & D4542-X WITH BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: -041/-042 = 0.38 lbs, -043/-044 = 0.27 lbs,
-045/-046 = 0.11 lbs, -047/-048 = 0.15 lbs
- 8) BEND INDIVIDUAL TABS ON D4541-X BRACKETS TO CORRESPONDING "A#" (A1, A2, ETC.,) VALUE

B	ADD FINISH (ZN A8-1)	CP	12.02.01
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.02.01		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4545	REV. B SHEET 1 OF 9
TITLE RETAINER, INNER	SCALE NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

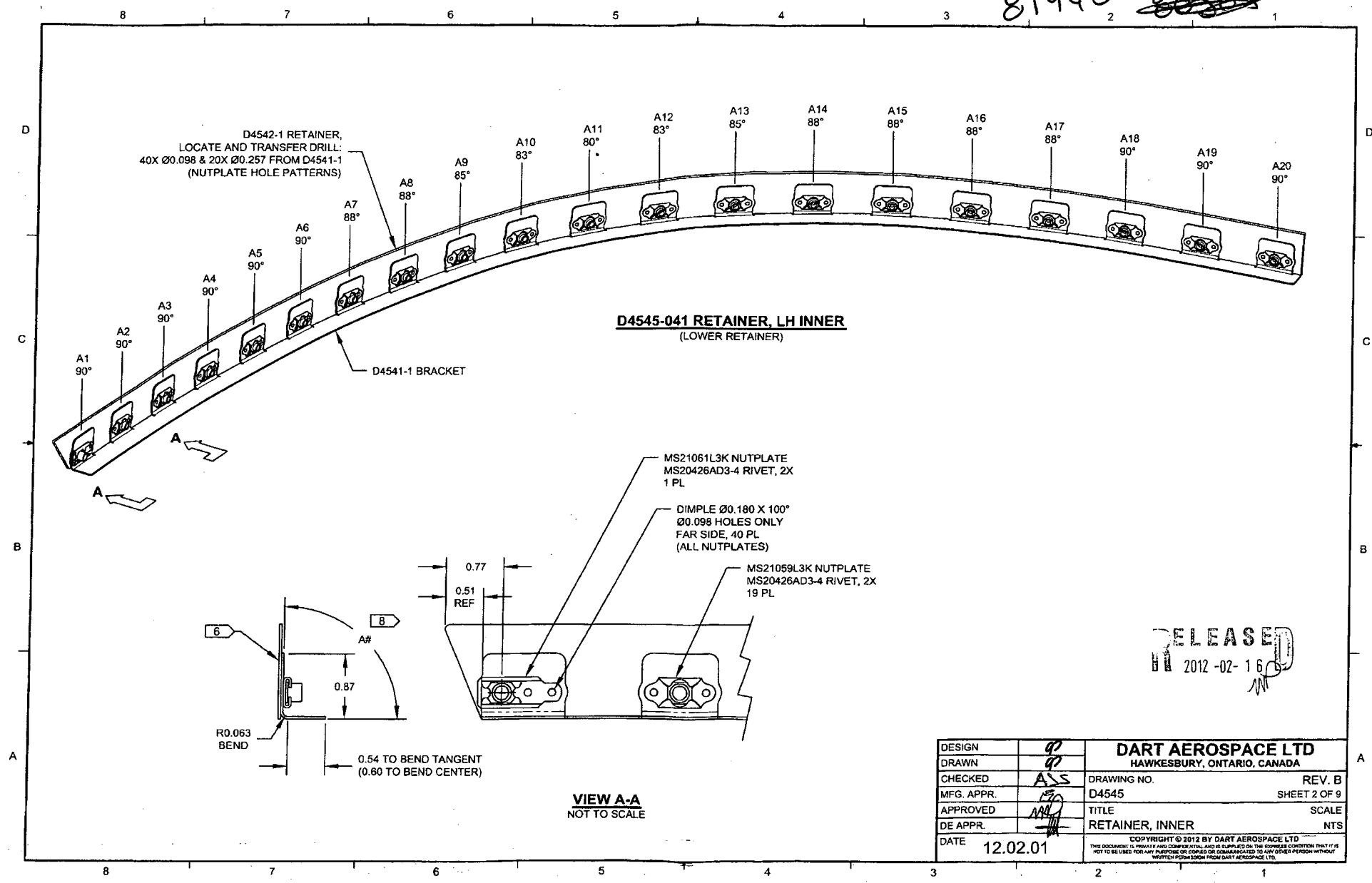
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81940 ~~80855~~



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2012-02-16

DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	92		
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.		D4545	SHEET 2 OF 9
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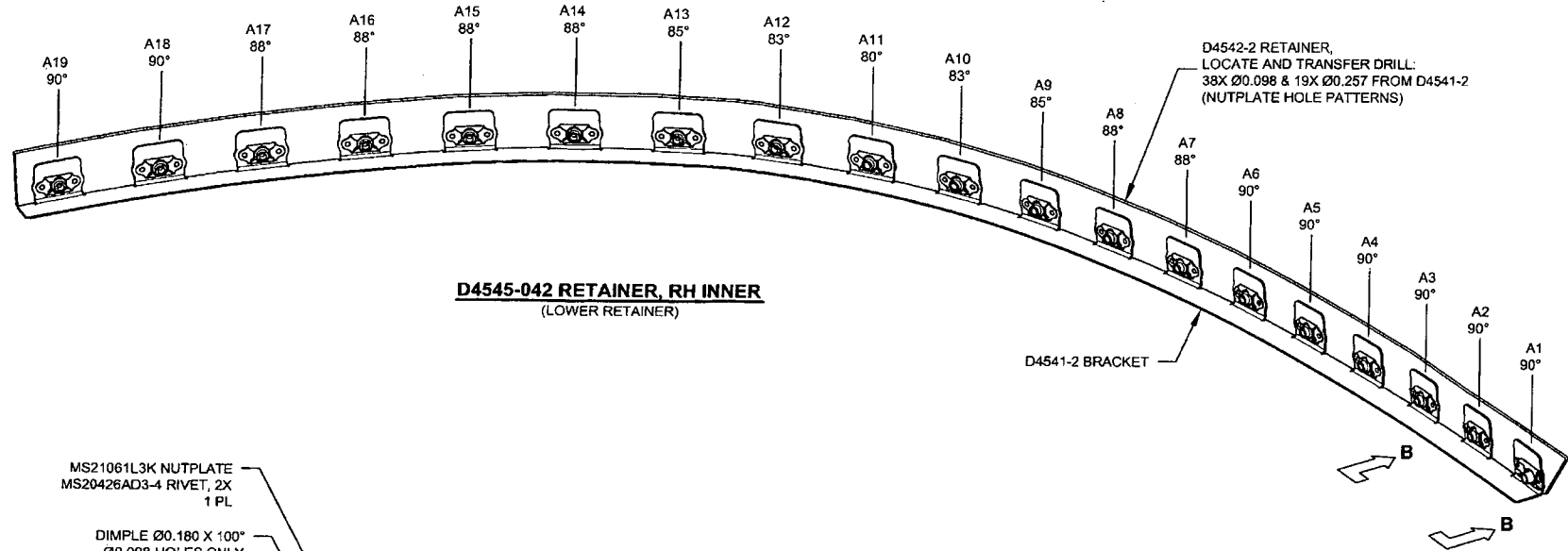
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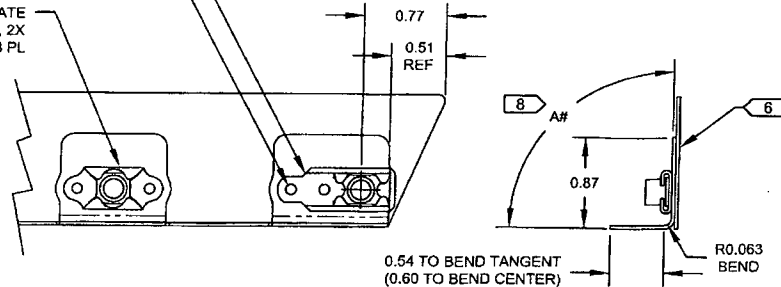
81940 ~~80525~~



MS21061L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
1 PL

DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 38 PL
(ALL NUTPLATES)

MS21059L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
18 PL



VIEW B-B
NOT TO SCALE

RELEASED
2012-02-16

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
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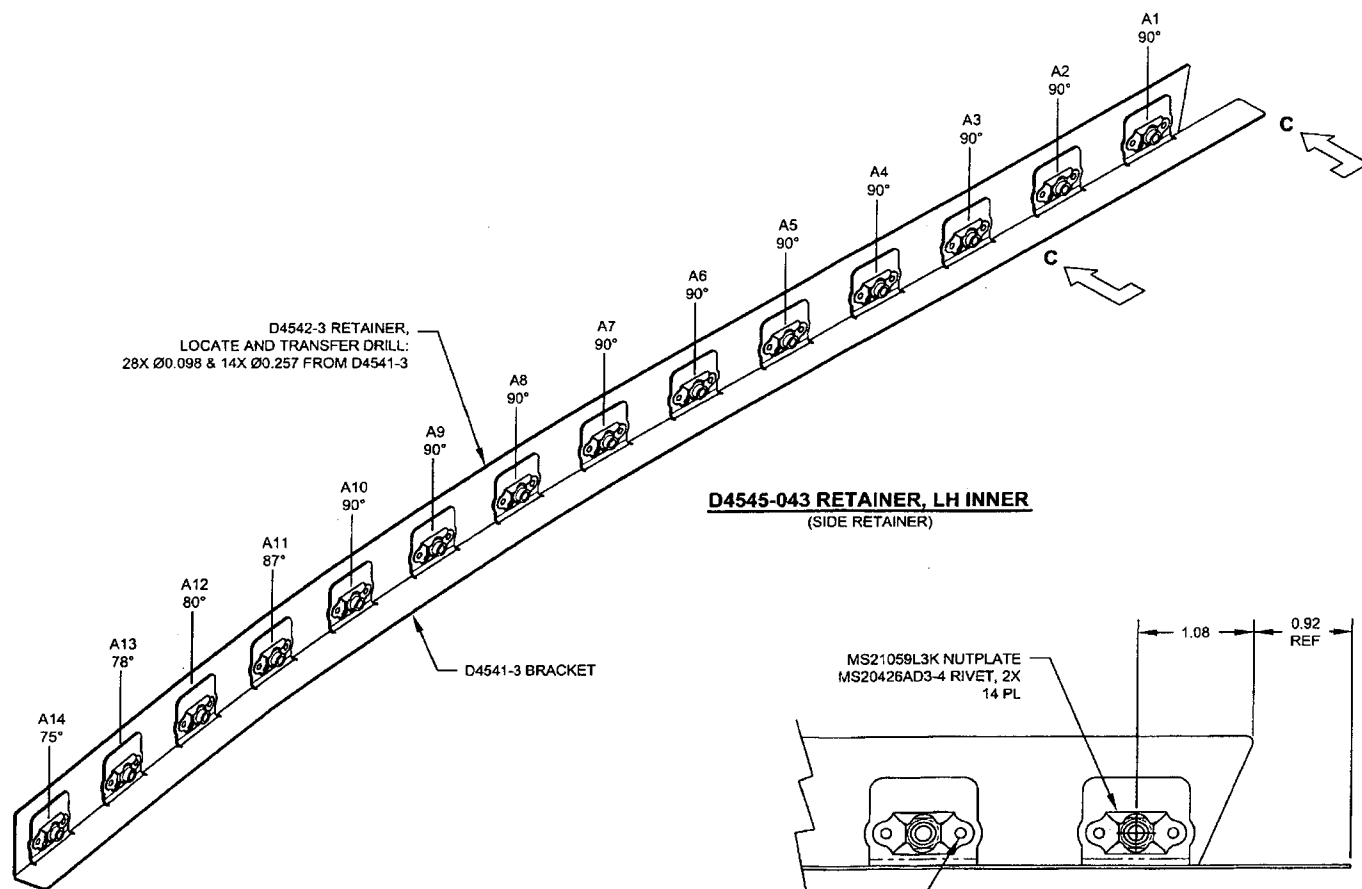
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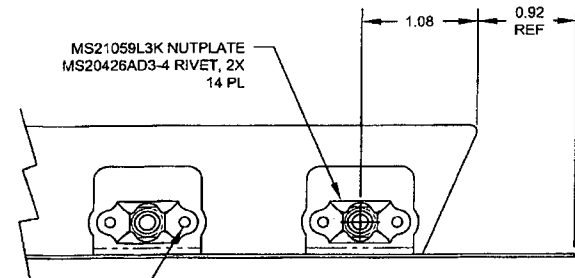
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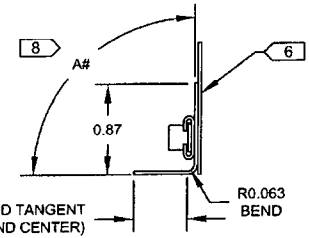


D4545-043 RETAINER, LH INNER
(SIDE RETAINER)

DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 28 PL

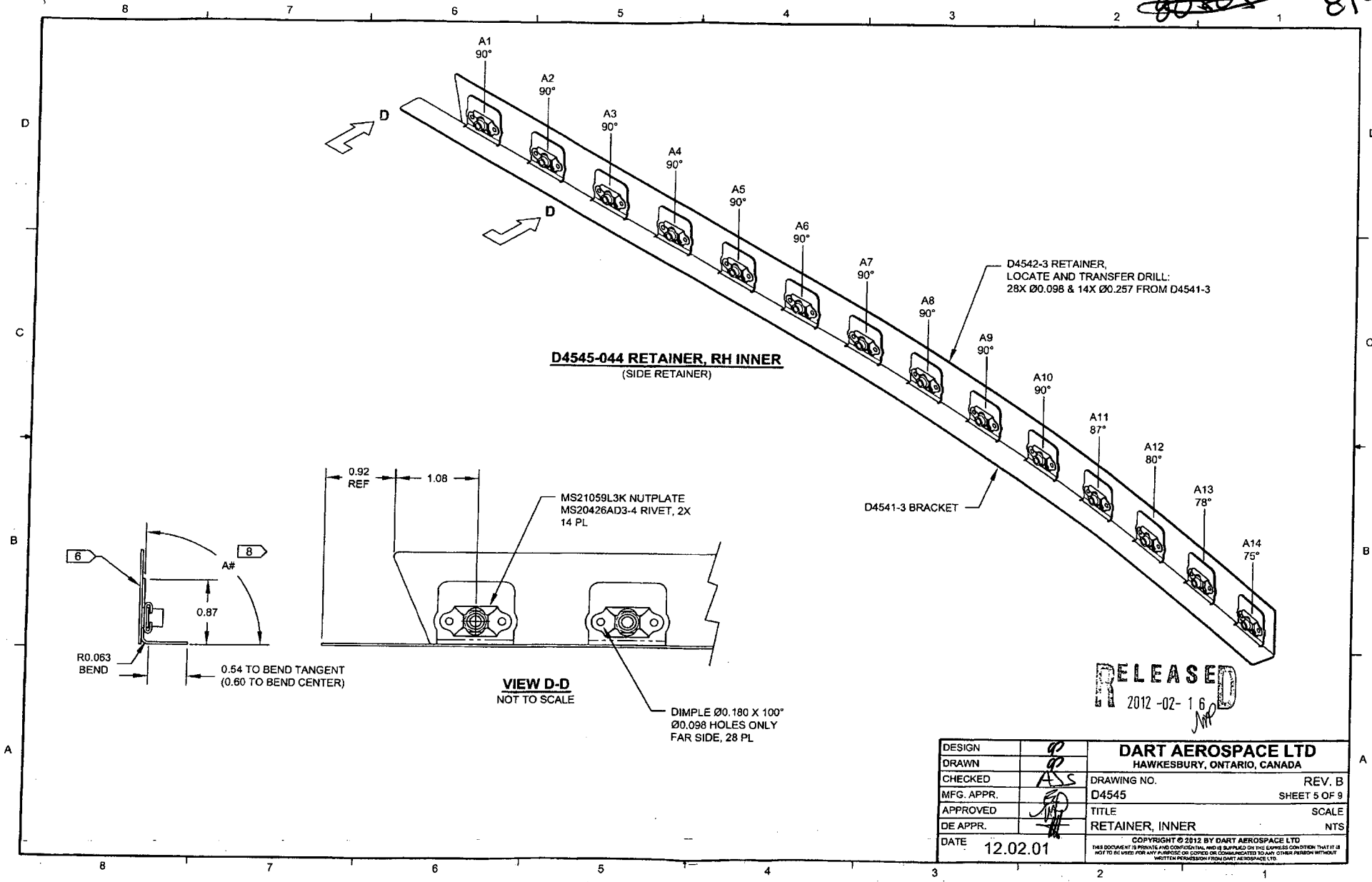


VIEW C-C
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80505 81940



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2012-02-16

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
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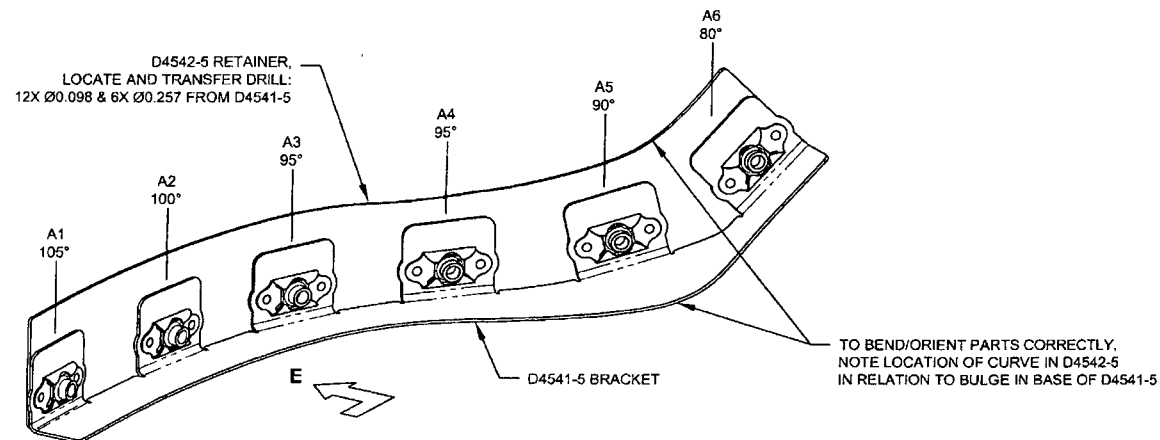
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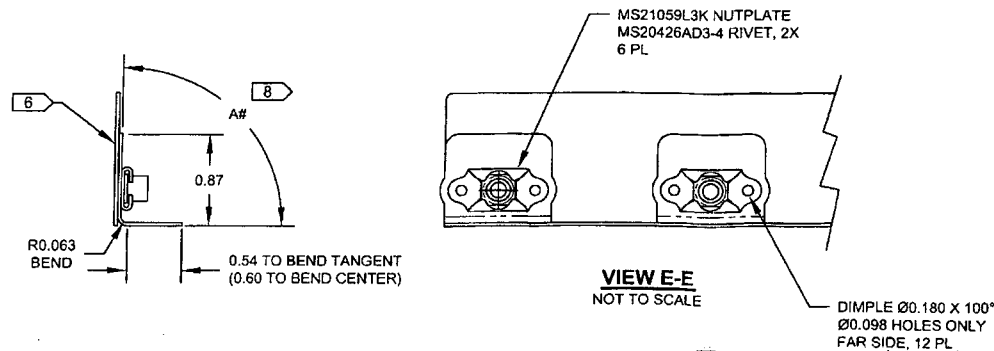
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81940



D4545-045 RETAINER, LH INNER
(TOP CORNER RETAINER)



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2012-02-16

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CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.		D4545	SHEET 6 OF 9
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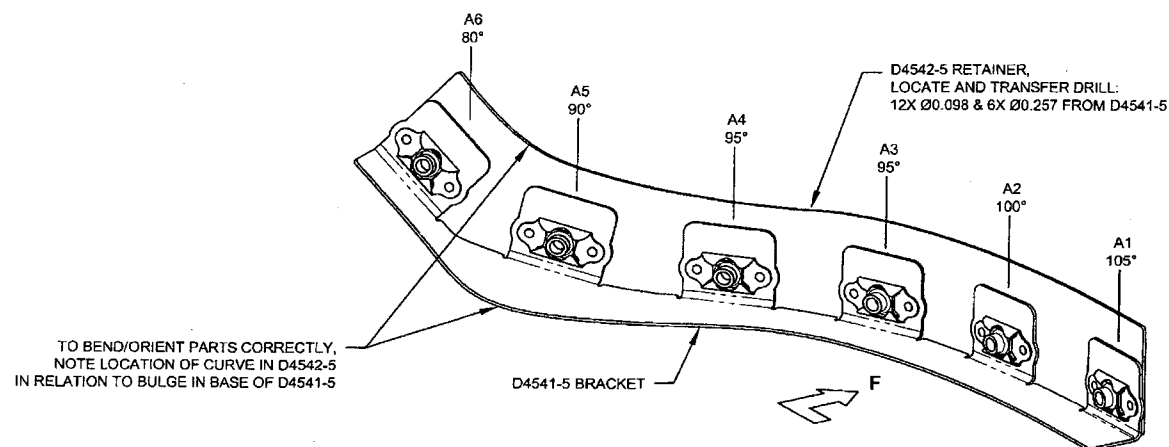
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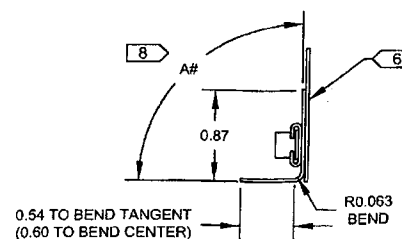
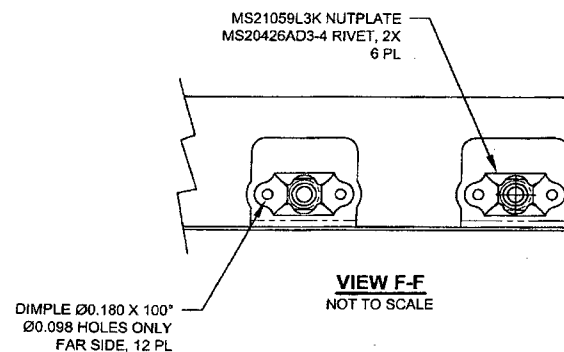
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NOTE: Date & initial all entries

~~80507~~ 81940



D4545-046 RETAINER, RH INNER
(TOP CORNER RETAINER)



RELEASED
2012-02-16
MD

DESIGN	9	DART AEROSPACE LTD	
DRAWN	9	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.		D4545	SHEET 7 OF 9
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, INNER	NTS
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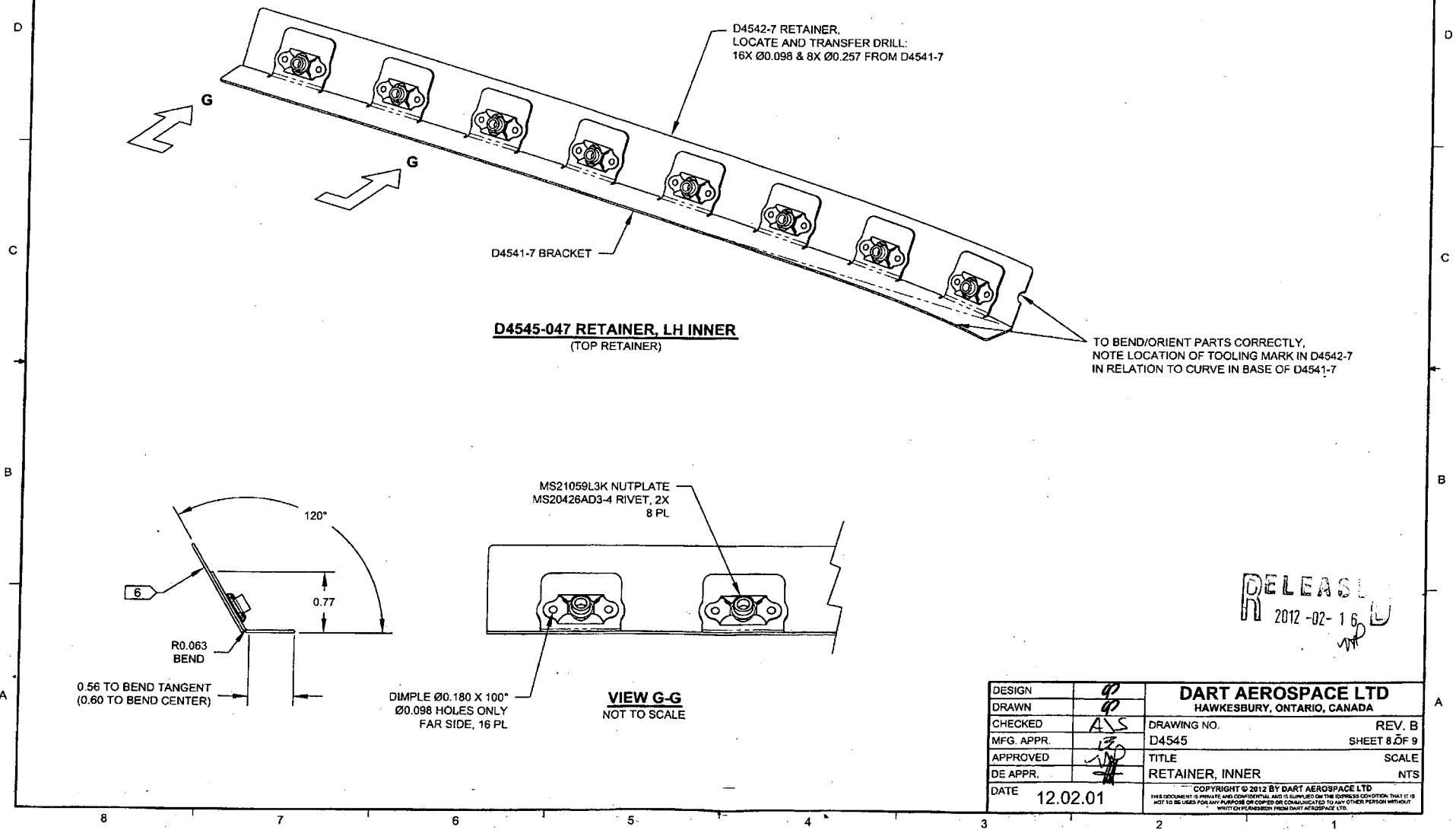
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DESIGN	90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	90		
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	130	D4545	SHEET 8 OF 9
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

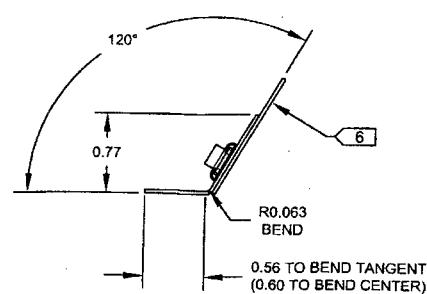
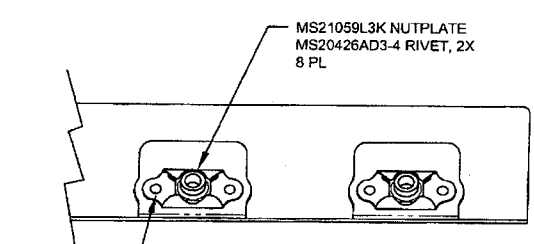
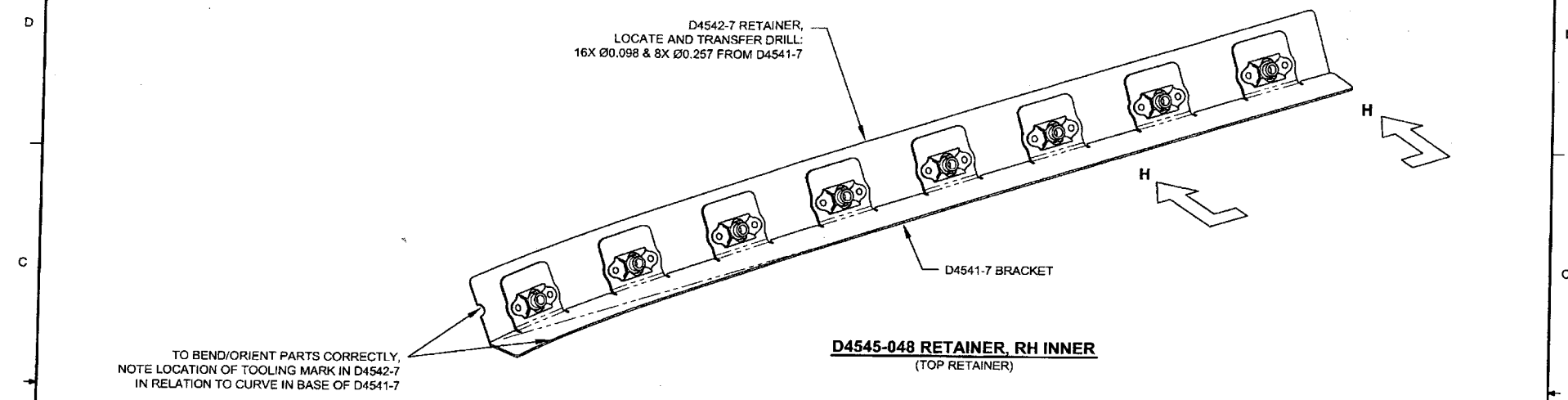
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries